Quality Control

Wednesday, November 24, 2010 8:48:39 AM

Memo



Page 1

Item ID: D3594-044 Accept Setup Start **Revision ID:** Stop Item Name: Floor Doubler Assembly, RH **Start Date: Start Qty: 10.00** 11/24/2010 **Cust Item ID: Required Date:** 11/30/2010 Req'd Qty: 10.00 **Customer:** Reference: Run Start Date: 101/24 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr Revision Nbr D3594 Rev B 100 0.00 FLOW WATER JET B10-11-29 Waterjet 0.00 Memo **B** □Prog Rev: <u>B</u> □2-FLOW CNC Waterjet 1-Cut as per Dwg D3594 □Dwg Rev: 6061.080 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B10-11-29 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

Dart Ae	rospace I	Ltd							
W/O:			WO	RK ORDER CHANGE	S				· · · · · ·
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ/	\	Date: _	
	Res	solution:	Disposition	:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC	Corrective Action Sec			Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
1,5									

Wednesday, November 24, 2010 8:48:39 AM



Page 2

Item ID:

D3594-044

Accept



Setup Start



Revision In:

Item Name:

Floor Doubler Assembly, RH

Start Date:

11/24/2010

Start Qty: 10.00

Required Date: 11/30/2010

Req'd Qty: 10.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date:_____

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Code

Accept Qty

Reject Oty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Memo

C'SINK AS PER DWG D3594

Run Hours 0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O



150

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

=) Il 10 (1/30

Memo

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHAN	IGES				- <u>-</u>	*
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR:	Yes	No DQ	A :	Date:	
	Re	esolution:	Disposition	on:	QA: I	VC CIO	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFOR	MANCE	(NCR)	`		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Descriptio Chief Eng	Section B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
					-					

Wednesday, November 24, 2010 8:48:39 AM



Page 3

Item ID:

D3594-044

Accept

Setup Start



Revision ID:

Item Name:

Floor Doubler Assembly, RH

Start Date:

11/24/2010

Start Qty: 10.00

Required Date: 11/30/2010

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

170

Small Fab

Small Fab

Small Fab

Memo

QC5- Inspect part completeness to step on W/O

Install Nut Plates As per Dwg D3594

0.00

0.00

180

QC

Quality Control

Memo

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·	<i>t</i>
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	_ NCF	R: Yes	No DQ	A:	_ Date: _	
		esolution:								
NCR:			WORK OR	DER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC			ion B	<u> </u>	Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
					-					
		·								



Page 4

Wednesday, November 24, 2010 8:48:39 AM

Item ID:

D3594-044

Accept



Setup Start

Stop



Revision In:

Item Name:

Floor Doubler Assembly, RH

Start Date:

11/24/2010

Start Oty: 10.00

Req'd Oty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Tooling:

Date:

Run

Start

Stop



Sequence ID/

Required Date: 11/30/2010

Date:

SPC (Y/N):

Set Up/

Tool ID

Date: Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID 190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Run Hours

0.00

0.00

200

Ouality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				ŧ
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	s No DQ	A:	Date:	i :
	R	esolution:	Dispositio	n:	_ QA: N/C (Closed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Dat		tion C	Chief Eng	QC Inspector
			i i						
						1			

Picklist Print

Wednesday, November 24, 2010 8:48:43 AM

Work Order ID: 64085

Parent Item:

D3594-044

Parent Iten. Name: Floor Doubler Assembly, RH



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 10.00

Required Qty: 10.00

C	٥m		40	۰

IPP Rev : A New Issue 07-01-22 EC

Location Loc Oty Loc Code ST316 S21 ST317 S3030 S116188 S3030 S116188 S3030 S116188 S3030 S116188 S3030 S116188 S3030 S116188 S1170 Sf 7.8150 O.51 S.368421 S1170 Sf S.368421 Sf Si170 Sf Sf Sf Sf Sf Sf Sf S	mponent Item ID/ m Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ST316 521 - 15541 521 ST317 3030 116188 3030 M6061T6S.080 Purchased No 170 sf 7.8150 0.51 5.368421		 		No			100	Each	3,551.000		²⁸ E/S 10	/11/30)	
ST317 3030 116188 3030 116188 3030					Location	!	Loc	<u>Oty</u>	Loc Code		/ '	•		
ST317 3030 116188 3030 M6061T6S.080 Purchased No 170 sf 7.8150 0.51 5.368421					ST316			521		_				
116188 30300 3030 3030 3030 3030 3030 3030 3030 3030 3030				•	•	15541		521		_	<i>3</i> 0			
Purchased No 170 sf 7.8150 0.51 5.368421					ST317									
Loc Oty Loc Code MAT 7.815 115689 7.815 115689 7.815 1176 (84) 1170 (8						116188		3030				. •		
Location Loc Oty Loc Code MAT 7.815 115689 7.815 170 Each 50.0000 1 10 11 36 170 1	061T6S.080			No			170	sf	7.8150		5.368421			
MAT 7.815 115689 7.815 MS21069-5 Purchased No 170 Each 50.0000 1 Anchor nuts Location Loc Oty Loc Code	1-T6 .080 Sheet											B10-11-79	ί	
115689 7.815 4821069-5 Purchased No 170 Each 50.0000 1 10 10 11 36 11 3					Location		Loc	<u>Qty</u>	Loc Code				<u>~</u>	
AS21069-5 Purchased No 170 Each 50.0000 1 10					MAT		7	7.815					(\mathcal{O})	
Anchor nuts Location Loc Oty Loc Code						115689	•	7.815		<u> </u>	15689		\bigcirc	
<u>Location</u> <u>Loc Oty</u> <u>Loc Code</u>			Purchased	No			170 .	Each	50.0000		B101	11/30		
	chor nuts						•					1		
						1	Loc		Loc Code	/	/			
					ST302			50		_	<u> </u>			
113725 35 <u>()</u> 114075 15										_	_10	-		

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGE	ES				,
DATE	STEP	PRC	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	,
	R	esolution:	Disposition	on:	QA: N/C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
i							·		
								·	



DART AEROSPACE LTD	Work Order:	04085
Description: Floor Doubler, RH	Part Number:	D3594-4
Inspection Dwg: D3594 Rev: B		Page 1 of 1

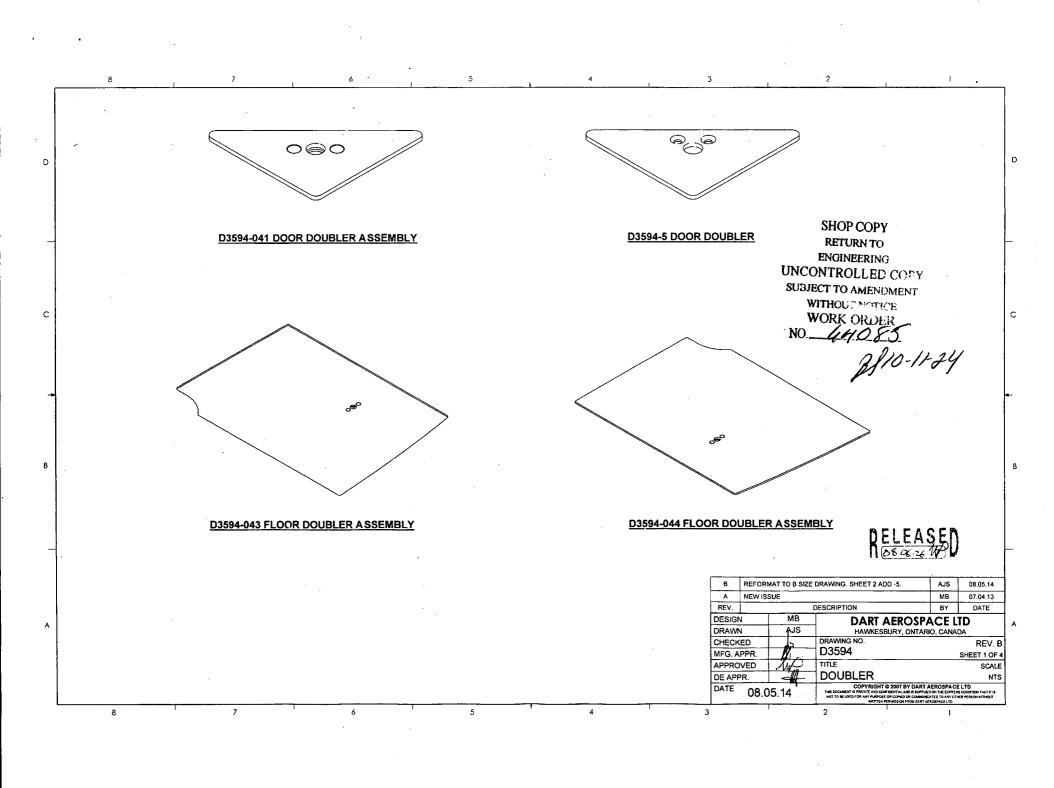
FIRST ARTICLE INSPECTION CHECKLIST

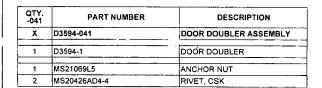
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	12.25	82		T 4301	
7.85	+/-0.030	7.846	>		V 1802	
7.313	+/-0.010	7.316	8		/	
2.688	+/-0.010	ગે.ધ્લા	4		V	
Ø0.323	+0.006/-0.001	.926	½		J	
Ø0.128	+0.005/-0.001	133	×		V	
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0.718	+/-0.010	วเร	7		V	
0.81	+/-0.030	.810	مل		V	
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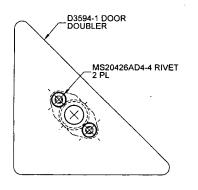
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Date: 10-11-79	Date: 10/4/59	Date:	N/A

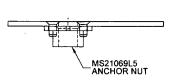
Rev	Date	Change	Revised by	Approved
Α (07.07.18	New Issue P/O D3594-044	KJ/JLM	
В	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC d	M





D





4 D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:
1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BRFAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

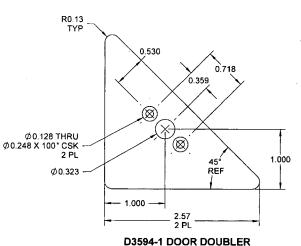
7) WEIGHT -041: 0.04 lbs

-5: 0.03 lbs

8

Ø0.128 THRU Ø0.248 X 100° CSK -2 PL 0.508 REF 0.359 2 PL

5



R0.13 TYP 0.530 \Re 45° 1.000 Ø0.323 REF - 1.000 -2.57 2 PL

5 D3594-5 DOOR DOUBLER B

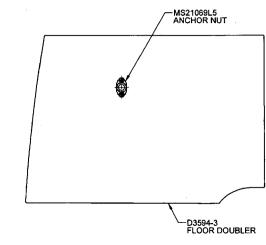
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	۵.	DRAWING NO.	REV. B
MFG. APPR.	2/	D3594	SHEET 2 OF 4
APPROVED	SVID	TITLE	SCALE
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DATE 08.0	5.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMITE AND GROWN BOTH AND IS SWELLED ON THE EXPRESS CONTINUE OF COMMITTEE OF THE PRIMITE ON COMMITTEE OF THE PRIMITE OF THE PRIMI	

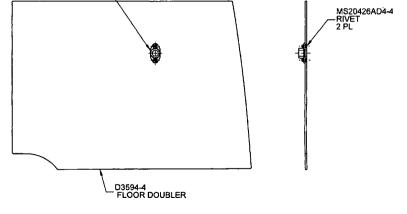
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2

5

QTY. -043	QTY. -044	PART NUMBER	DECCRIPTION	
x		D3594-043	FLOOR DOUBLER ASSEMBLY, LH	
	х	D3594-044	FLOOR DOUBLER ASSEMBLY, RH	
1	D3594-3	FLOOR DOUBLER, LH		
	1	D3594-4	FLOOR DOUBLER, RH	
1	1	MS21069L5	ANCHOR NUT	
2	2 2 MS20426AD4-4		RIVET, CSK	





D3594-043 FLOOR DOUBLER ASSEMBLY

W 0 440 85

MS20426AD4-4 RIVET--2 PL

NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-Q43/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044: 0.80 lbs

D3594-044 FLOOR DOUBLER ASSEMBLY

MS21069L5 ANCHOR NUT

D

С

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	\mathcal{D}	D3594	SHEET 3 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	4	DOUBLER	NTS
DATE 08.05.14		COPYRIGHT 6 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS REPAIRE AND COMPRISHMA. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PARROSE ON CONSECUENT CONMUNICATION ONLY OTHER PERSON WITHOUT WINTEN PERSONS FROM DART AUXIOUPLE; LTD.	

